

Work Order ID 109670

November-25-13 10:14:59 AM

109670

Page 1

Item ID: D4095-049 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Wearpad Assembly
 Start Date: 11/25/13 Start Qty: 10.00 *10*
 Required Date: 12/09/13 Req'd Qty: 10.00 *10* 12*
 Reference: Cust Item ID:
 Customer:

Approvals: Process Plan: MLJ Date: 13-11-25 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start *NR1*
 Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4095	B								
100	FLOW WATER JET	0.00				12	0		<u>Ac</u> 13-11-26
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg (D4095-9)								
	Dwg Rev: <u>3</u>								
	Prog Rev: <u>3</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00				12	0		<u>Ac</u> 13-11-26
110									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00				12			
120									
QC	Memo	0.00							
Quality Control									

DAS

27

9-89

13/11/26

Work Order ID 109670

November-25-13 10:14:59 AM

109670

Page 2

Item ID: D4095-049 Accept ***N900040100*** Setup Start ***NS1***
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 Required Date: 12/09/13 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC Brake NC	Form as per dwg NC BRAKE Memo	0.00 0.00				<u>12</u>			13/11/27
				DAS 30 9-89					
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		DAS 27 9-89 13/11/27		<u>12</u>			
150 *150* Large Fab Large Fab	Weld per dwg A/R Hardcoat S.S. Batch <u>1127112</u> Large Fab Memo	0.00 0.00				<u>12</u>			13-11-27 JAL

Work Order ID 109670

November-25-13 10:14:59 AM

109670

Page 3

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00		Smb 13/11/27		10			
170 *170* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		Smb 13/11/27		10			
180 *180* HandFinish Hand Finishing	HandFinish COAT ENTIRE TOP (CONCAVE) SURFACE WITH ROCKGUARD AS PER DWG A/R ROCKGUARD BATCH: 125335	0.00 0.00				12	0	0	13-11-27

Work Order ID 109670

November-25-13 10:14:59 AM

109670

Page 4

Item ID: D4095-049 Accept ***N900040100*** Setup Start ***NS1***
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 Required Date: 12/09/13 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC3- Inspect Part Finish	0.00							
100						12			13-11-28
QC	Memo	0.00							
Quality Control									
200	Identify as per dwg & Stock Location: <u>FP-001</u>	0.00							
200						x12	4	HL	13/11/28
Packaging	Memo	0.00							
Packaging									
210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.00							
Quality Control									

[Signature] / Rm 13/11/28.
 MF
 13-11-28

Picklist Print

November-25-13 10:15:02 AM

Page 1 / 1

Work Order ID: 109670

109670

Parent Item: D4095-049

D4095-049

Parent Item Name: Wearpad Assembly

Start Date: 11/25/13

Required Date: 12/09/13

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP rev.A 11.11.07 new issue EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S16GA		Purchased	No				sf	352.2540					
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M304S16GA

304/316 Sheet .063

Ac 13.11.26

Location

Loc Qty

Loc Code

MAT020

352.2539998

123136

140.2

M126159

26.22


M126915

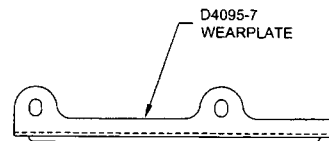
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126915 → 2.4

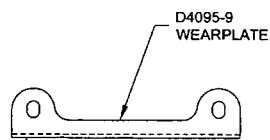
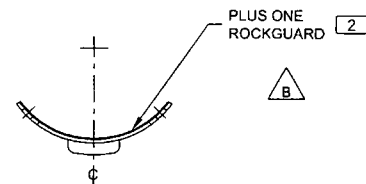
FIRST ARTICLE INSPECTION CHECKLIST

DAS

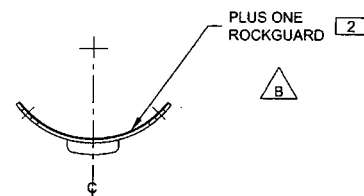
Rev	Date	Change	Revised by	Approved
A	11.11.08	New Issue P/O D4095-049	KJ	



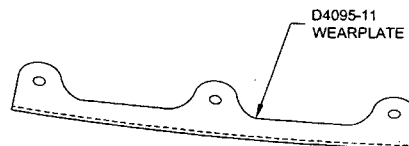
D4095-047 WEAR PAD ASSEMBLY



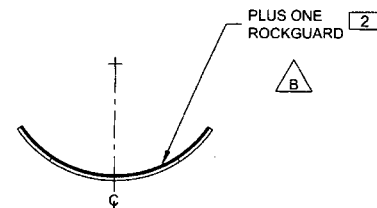
D4095-049 WEAR PAD ASSEMBLY



109670MLD
13-11-25

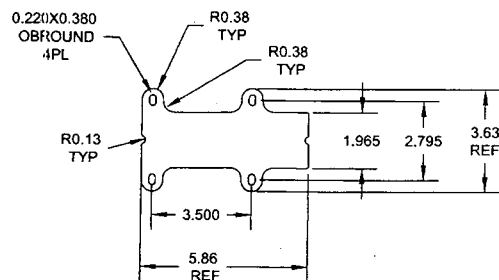


D4095-051 WEARPAD ASSEMBLY

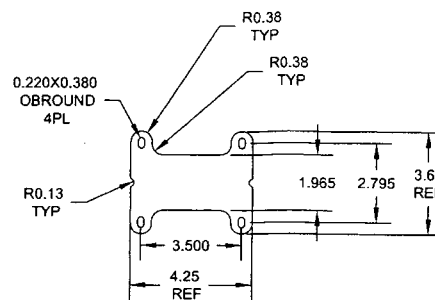


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2011-10-31
JMB

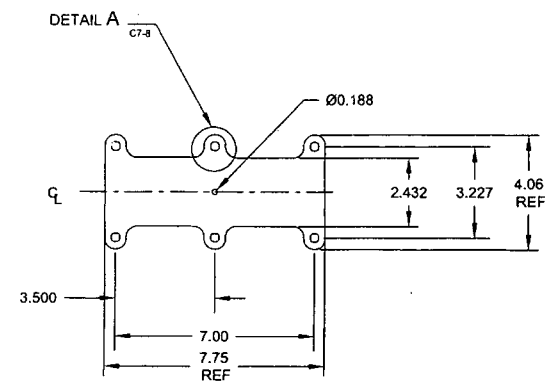
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MFG. APPR.	140	D4095	SHEET 2 OF 8
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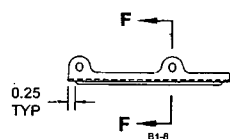
D4095-7F FLAT PATTERN 1



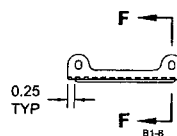
D4095-9F FLAT PATTERN 1



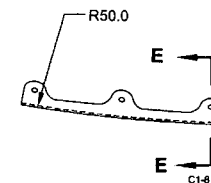
D4095-11F FLAT PATTERN 1



D4095-7 LONGITUDINAL BEND
(MADE FROM D4095-7F)



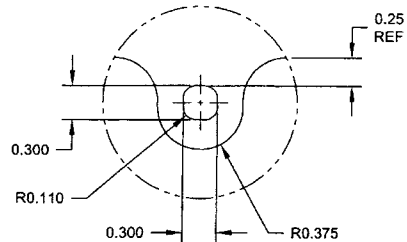
D4095-9 LONGITUDINAL BEND
(MADE FROM D4095-9F)



D4095-11 BENDING DETAIL
(MAKE FROM D4095-11F)

2011-10-31

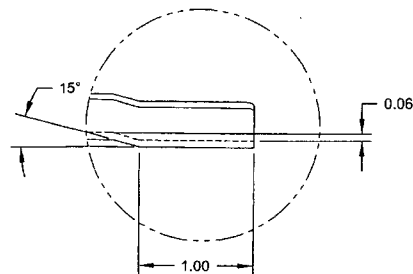
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DETAIL A: TAB DETAIL

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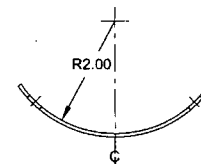
C3-3
C3-4
D3-6
D2-7



DETAIL B: JOGGLE DETAIL

SCALE 4X

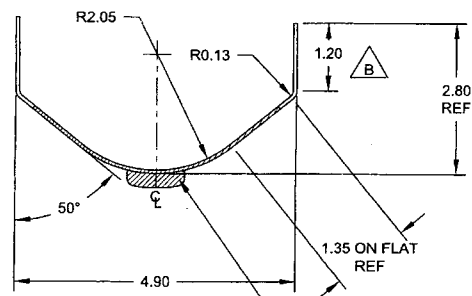
B2-3
B6-3
S3-4
B2-6



SECTION E-E

SCALE 2X

B5-6
B2-7

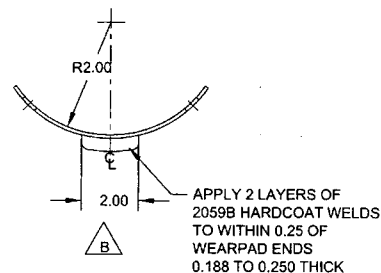


SECTION C-C

SCALE 2X

B5-3
B4-4

APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK

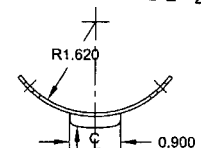


SECTION D-D

SCALE 2X

B4-3
B5-4

APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK



SECTION F-F

SCALE 2X

B5-7
B7-7

APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK

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